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15330

D2012-105
Job Sheet 193229



Part No: D2012-105

Job Qty: 6 pcs

Part Name: Arm (31.06)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No: 15330

Due Date: 4/26/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV E IPP Rev: 02.04.03 Added Inspect level 3 NG

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - Brake NC 32.15	6 pcs	4/26/19		0.00	1.70	Small Fab - Brake - 1		DAS 58 9-89 APR 29 2019
							Small Fab - Brake - 2		
							Small Fab - Brake - 3		
110	Small Fab - 2 - B4B	6 pcs	4/26/19		0.00	1.11	Small Fab - 1 - B4B		DAS 58 9-89 APR 29 2019
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 5	6 pcs	4/26/19		0.00	0.00	QC 5 - 10		DAS 40 9-89 APR 29 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Powdercoat - 1 Black Sand - B4B 11138940	6 pcs	4/26/19		0.00	0.21	Powdercoat - 1 - B4B		DAS 40 9-89 APR 29 2019
							Powdercoat - 2 - B4B		
							Powdercoat - 3 - B4B		

START: 7:00 A.T. 300° FINISH: 8:20

140 QC 3	6 pcs	4/26/19	0.00 0.00	Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
150 Packaging 3-1 - Stock - B4B	6 pcs	4/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 -	

DAS
 MAY 0 7 2019
 40
 9-89

				B4B	
				Packaging 3 - 27 - B4B	St 377 MAY 07 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	6 pcs	4/26/19	0.00 0.00	QC 21 - SA - 21	DAG MAY 08 2019
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-35

Part Op **100** - (Bend/Assemble as per dwg) Punch to length as per Dwg D2012-105 & template D2012-105T1 and DT8116 Use
 Descriptions: DT10255 TO CHECK PART
110 - (Small Fab) 1-Deburr
120 - (QC5- Inspect part completeness to step on W/O) Use DT10255 TO CHECK PART
130 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
140 - (QC3- Inspect Part Finish)
150 - (Identify as per dwg & Stock Location: _____)
160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.500W.035	304 Round Tube .500 X .035W	15.7524 ft (2.6254 ea)	100-Small Fab - Brake NC	873356

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - Brake NC	M304TR0.500W.035	16	76	0

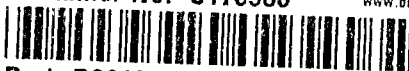
Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	31.900Inches ± 0.030	31.930 31.870		
2	Arm	31.060Inches ± 0.030	31.090 31.030		
3	Arm	0.257Inches + 0.006 - 0.001	0.263 0.256		



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Container No: S175985



Part: D2012-105

Job No: 193229

Serial No/Batch: S175985

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/23/19